

Work Order ID 77178

77178

Page 1

November-28-11 9:02:37 AM

Item ID: D412-750-142

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Light Fairing, RH

Start Date: 28/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/28 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| N/A | Rev A |

***SP**

100 0.00

100

DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy bluefile & type labels per PPP D412-750-142 CHG001

Sulido

Ger M.L.J 11-12-7
(5)

110 0.00

110

Pick Kit

Packaging Memo 0.00

Packaging

SP 11-12-07

120 0.00

120

QC4- 100% Inspect kits for completeness

QC Memo 0.00

Quality Control ***** Ensure part is a R/H as per dwg *****

Sulido

XS
RH

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 77178

77178

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November-28-11 9:02:37 AM

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5

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D412-750-142 Location: <u>123</u> PPP Rev: <u>A</u> | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10/12/8 *(SD)*

11/12/8 *MF*
11-12-08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

November-28-11 9:02:40 AM

77178

D412-750-142

Required Date: 12/12/2011

Required Qty: 5.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

10 50

SP.

Loc Code

$3x$.

47x

0.0000

m119537 SP.

0.0000

B⁵ 75828 SP

11-12-07.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

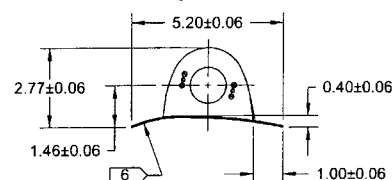
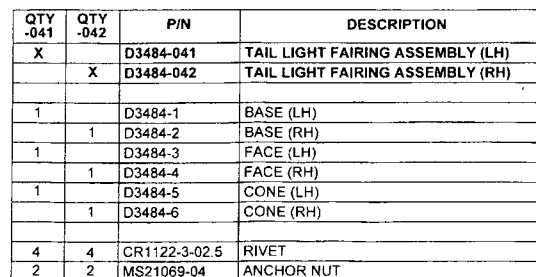
4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|-----------------------------------|---------|---------|------------|--------------|-------------|
| | | Arm | Moment | Arm | Moment |
| D412-750-141 | 0.13 lb | 6.0 in | 0.78 lb-in | 296.1 in | 38.49 lb-in |
| <i>Tail Light Fairing Kit, LH</i> | 0.06 kg | 0.2 m | 0.01 kg-m | 7.5 m | 0.45 kg-m |
| D412-750-142 | 0.13 lb | 6.0 in | 0.78 lb-in | 296.1 in | 38.49 lb-in |
| <i>Tail Light Fairing Kit, RH</i> | 0.06 kg | 0.2 m | 0.01 kg-m | 7.5 m | 0.45 kg-m |

5.0 PARTS LIST

| Qty - 141 | Qty - 142 | Part Number | Description |
|--------------|--------------|--------------|------------------------------|
| X | | D412-750-141 | TAIL LIGHT FAIRING KIT, LH |
| | X | D412-750-142 | TAIL LIGHT FAIRING KIT, RH |
| | | | |
| 1 | | D3484-041 | TAIL LIGHT FAIRING ASS'Y, LH |
| | 1 | D3484-042 | TAIL LIGHT FAIRING ASS'Y, RH |
| | | | |
| 10 | 10 | AN3-3A | BOLT |
| 10 | 10 | AN960JD10 | WASHER |
| | | | |



SECTION A-A


SECTION B-B

D3484-041 TAIL LIGHT FAIRING

D3484-041 ISOMETRIC VIEW

D3484-042 | ISOMETRIC VIEW

RELEASE
9/24/41

| | | | |
|------------|--|--|------------|
| F | UPDATE MATERIAL SPEC. ADD 8081-0, ZN A7-2, ZN A7-3, B3-4, UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1 | | 09.03.31 |
| E | REDRAW/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET | MB | 08.01.03 |
| D | CORRECT D3484-1F | MB | 06.06.22 |
| C | RE-DESIGN D3484-3F1-5F | MB | 06.04.20 |
| B | RE-DESIGN | MB | 06.02.21 |
| A | NEW ISSUE | MB | 05.11.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN |  DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | | | |
| CHECKED | | DRAWING NO. | REV. |
| MFG. APPR. | | D3484 | SHEET 1 OF |
| APPROVED | | TITLE | SCALE |
| DE APPR. | TAIL LIGHT FAIRING | | 1 |
| DATE | 09.03.31 | COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED TO THE EXCLUSIVE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY. | |